

Order ID 76640-1

er 18, 2011 10:23:17 AM

: D2230-1

1 ID:

me: Lug

ate: 11/18/11

d Date: 11/25/11

ce:

als:

Process Plan:

QC:

e ID/

enter ID

Nbr

Revision Nbr

Rev G

*

dsaw

*

vertical machine #1

BAND SAW

Memo

Cut D2423 extrusion to 0.82"
Batch: 66331

extrusion cut @ 4 mils

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FA927
DWG REV:
FOLIO REV:
(Check for crack while loading into the machine.)
2- deburr rough edges

elbow P/O: 10 mils

Machine as per plug D 2230 REV.G

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Date: 11/18/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

P/O. 15479

Work Order ID 76640

76640

Page 2

November 18, 2011 10:23:17 AM

Item ID: D2230-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Lug

Stop *NS2*

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 *see'd*
120

QC2- Inspect parts off-machine FAI/FAIB

0.00

QC
Quality Control

Memo

0.00

*see'd + inspect for transit damage
attached c/c to W/D*

11/19/11 (200)

130
130

QC6- Inspect parts - second check

0.00

QC
Quality Control

Memo

0.00

See 11/18/11

*center
+200
QSP019*

140
140

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish
Hand Finishing

Memo

0.00

200 BR 11-18-11

Work Order ID 76640

November 18, 2011 10:23:17 AM

76640

Page 3

Item ID: D2230-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

2 ~~Bl~~ 11-12-8
M-L

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Glossy Blach
0.00 11-10
3200 F
11-40

2X M-L 11/12/08

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

2 Bl 11-12-8.

M 118025

Work Order ID 76640

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76640

Page 4

Item ID: D2230-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug

Stop ***NS2***

Start Date: 11/18/11 Start Qty: 160.00

160

Cust Item ID:

Required Date: 11/25/11 Req'd Qty: 160.00

160

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

SNIP

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/12/11

MF 11-12-08

Picklist Print

November 18, 2011 10:23:17 AM

Page 1

Work Order ID: 76640

Parent Item: D2230-1

Parent Item Name: Lug

Start Date: 11/18/11

Required Date: 11/25/11

Start Qty: 160.00

Required Qty: 160.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P ✓		Purchased	No				Each	0.0000					
LUG													
D2423		Manufactured	No			110	f	455.0800	0.0683	11-503158			
Lug Extrusion													

Location

Loc Qty

Loc Code

MAT006

455.08

43722

161.5

45800

1

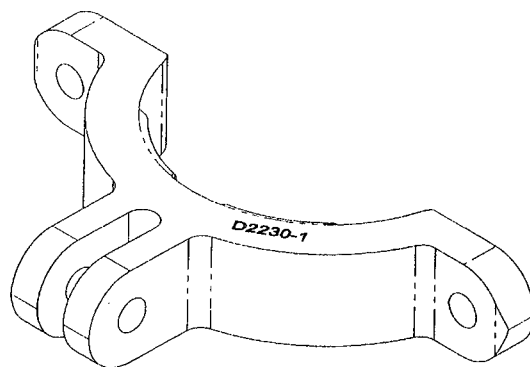
68331

292.58

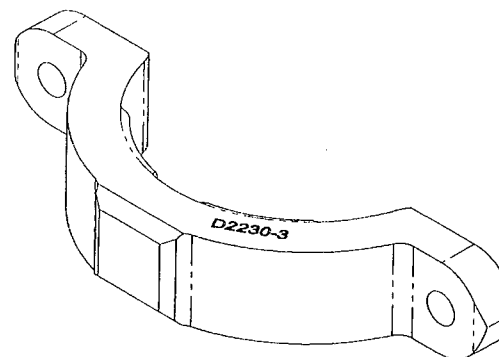
13.66

13.66

160
200
Camp 3
CL 11/18



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

02111118
W/O: 76640

RELEASED
09/06/15

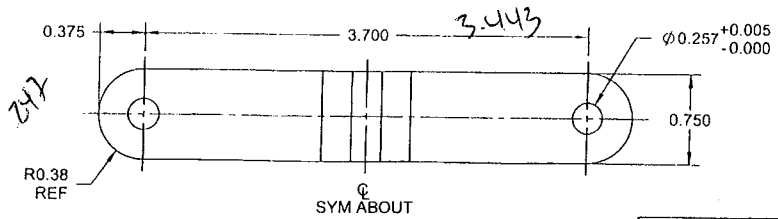
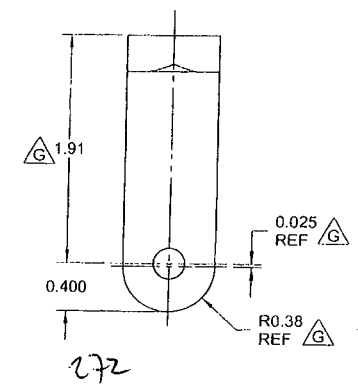
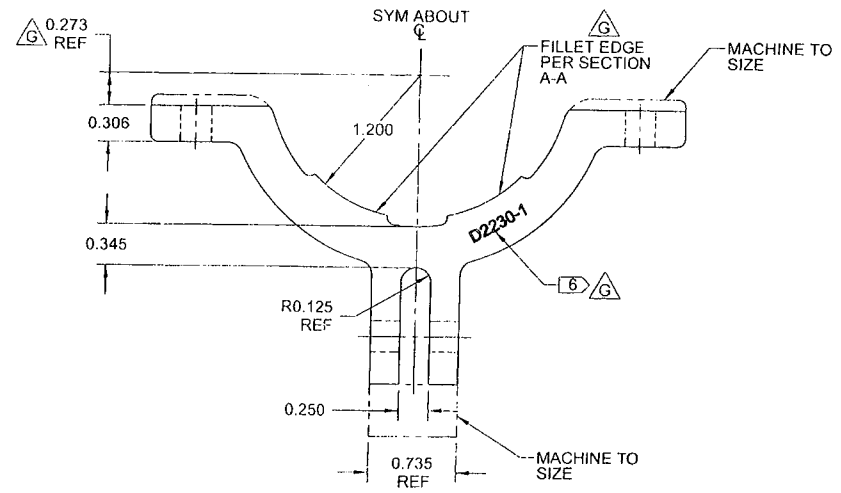
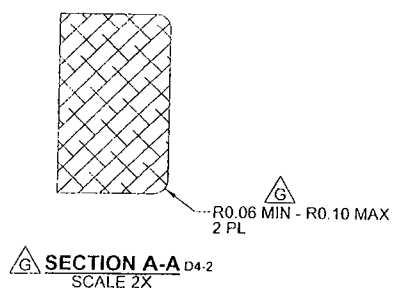
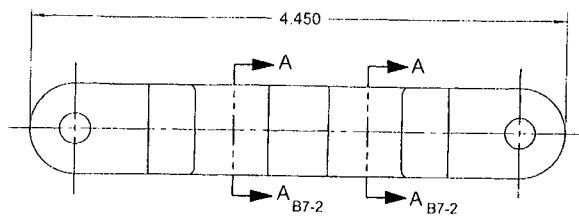


NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005 .
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2230 MOUNTING LUG <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS LOANED TO YOU BY DART AEROSPACE LTD FOR YOUR USE ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.16	REV. G SHEET 1 OF 3 SCALE NTS	

60
170
180

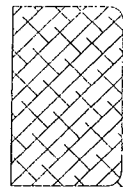
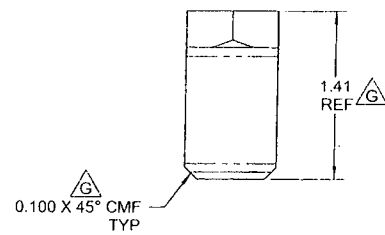
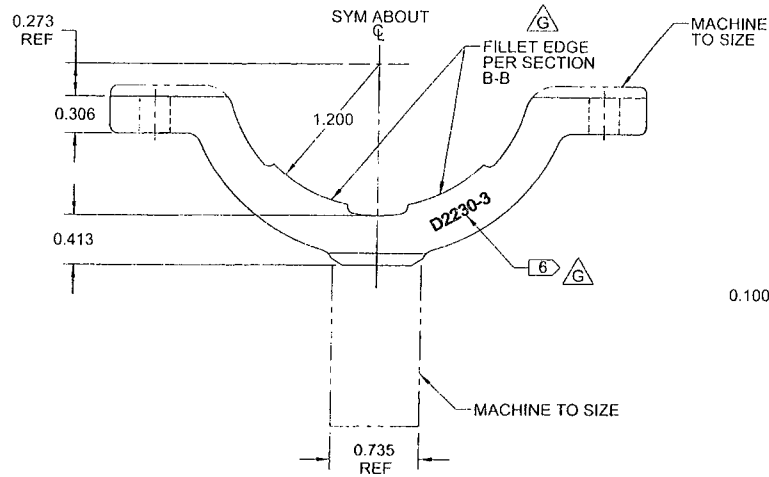
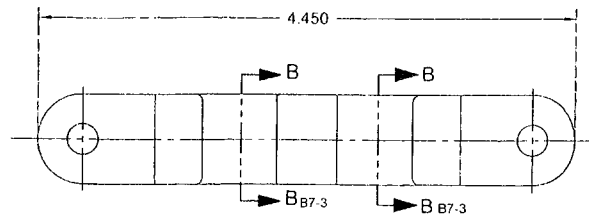


D2230-1 MOUNTING LUG

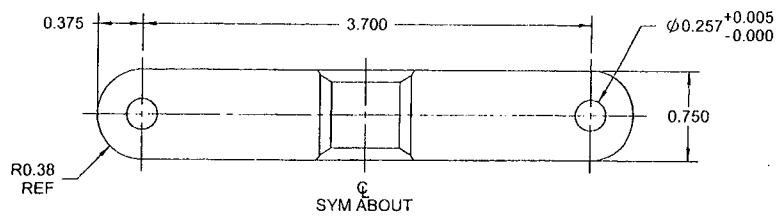
RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE	SCALE
APPROVED		MOUNTING LUG	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND CONFIDENTIAL. NO DISSEMINATION OF THIS DOCUMENT IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	09.01.16		

8 7 6 5 4 3 2 1



SECTION B-B D4-3
SCALE 2X
R0.06 MIN - R0.10 MAX
2 PL



RELEASED
09/06/2014

D2230-3 MOUNTING LUG

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15479

Purchase Order Date 11/18/11

PO Print Date 11/18/11

Page Number 1 of 1

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, QC K0B 1R0
CA

Contact Name

Vendor Phone

613 678 3957

Vendor Fax

613 678 3956

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

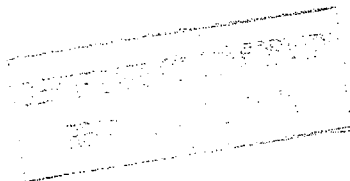
6/11/15

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
D2230-1P		LUG	11/21/11 Yes	200.00 Each	Dart Truck	\$18.9500	\$3,790.00
Special Inst: MACHINE AS PER DWG D2230 REV. G B76640							
D2230-3P		LUG	11/18/11 Yes	200.00 Each	Dart Truck	\$13.6000	\$2,720.00

Special Inst: MACHINE AS PER DWG D2230 REV. G
B76642

PO Total:

\$6,510.00



Change Nbr: 1

Change Date: 11/18/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

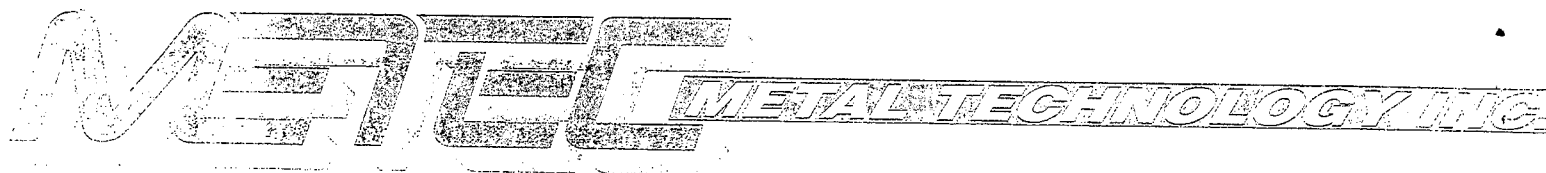


20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 18274
Date: Nov 21, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15479	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Nov 22, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, machine as per drawing D2230 REV.G B76640	Each	200	200	
D2230-3 Mounting Lug, machine as per drawing DWG D2230 REV.G B76642	Each	200		200
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

200

D2230-1

Mounting Lug

15479

MATERIAL: supplied by DART D2423 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, November 21 2011